

Work Order ID 135671

Monday, August 17, 2015 7:20:31 AM

135671

BLUE

Page 1

Item ID: D206-642-341

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 8/14/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/14/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 8-18-15 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2650	F(DEO)

100	Document Control	0.00
-----	------------------	------

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-642-341 CHG005

N/A SEP 08 2015 MLJ

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Required Date: 8/14/2015 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

Skidtubes

Memo

0.02

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/RAluminum Rod M31562

4-Grind weld flush to cap on top surface only.

5-Cut aft end to lenght as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11- Ream holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)

12-Deburr.

DGC 15-8-19

DGC 15-08-20

DGC 15-8-24

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Required Date: 8/14/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00

115

QC

Memo

0.00

Quality Control

DAS
38
9-89

AUG 25 2015

116

QC9- Inspect visual per QSI004- Fusion Welds

0.00

116

QC

Memo

0.00

Quality Control

① 15-08-25

DAS
9
9-89

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.01

Hand Finishing

1 2 15-8-25 JH

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Item ID: D206-642-341

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 8/14/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/14/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	QC7-Inspect Chemical Conversion Coat	0.00							
125									
QC	Memo	0.00							
Quality Control									
130		0.00							
130									
Skidtubes	Skidtubes								
Skidtubes	Memo	0.01							
	1- Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting								
	Start Date: _____ Time: _____								
	Finish Date: _____ Time: _____								
	A/RSikaflex-291 <u>132905</u>								
	Sikaflex expiry date: <u>16-2-12</u>								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

15-8-26 DGC

1 15-8-26 DGC

DAS
03
9-89

15-8-27

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Item ID: D206-642-341

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Cust Item ID:

Required Date: 8/14/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Skidtubes	0.00							
150									
Skidtubes	Memo	0.02							
Skidtubes	1- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002								
	2- Install nut plate as per dwg								
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									
190	Pressure Wash per QSI005 4.3	0.00							
190									
HandFinish	Memo	0.01							
Hand Finishing									

DAS
38
9-89
AUG 27 2015

1 15-8-31 266

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Item ID: D206-642-341 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube (Fits LH or RH)
 Start Date: 8/14/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/14/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
205	Spray Painting per QS1005 4.2	0.00				1			DAS 41 9-89
205									
SprayPaint	Memo	0.00							15-9-1
Spray Painting	TEMPO PRIMER B 132122 Delfleet BLUE B 132641 Delfleet CLEAR B 129271 PRIME: 132120 START TIME: 8:00 FINISH TIME: 8:30 PAINT: 132641 START TIME: 11:30 FINISH TIME: 12:00								
206	QC14- Inspect Spray Paint	0.00							
206									
QC	Memo	0.00							
Quality Control									

1x of 92 15/09/03 DAS 15 9-89

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Item ID: D206-642-341

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N900040100Setup Start ***NS1***

Revision ID:

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Stop ***NS2***

Start Date: 8/14/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/14/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

0.00

220

HandFinishing

HandFinish

Memo

0.03

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/RSikaflex-291 11131297Sikaflex expiry date: 15109

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

RTU 598 11131311 1611

3-Install MS27039-4-06 Screw

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/RSikaflex-291 11131297Sikaflex expiry date: 15109

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: 11132291x 1 11 15/09/10

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Start Date: 8/14/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/14/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

QC3- Inspect Part Finish

0.00

230

QC

Memo

0.00

Quality Control

DAS

9

9-89

① 15-09-03

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

DAS

9

9-89

① 15-09-03

250

Packaging

0.00

250

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-341
Location:FG083DAS
6
9-89

SEP 08 2015

① 13-06-56

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Item ID: D206-642-341

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube (Fits LH or RH)

Stop ***NS2***Start Date: 8/14/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/14/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC21- Final Inspection - Work Order Release

0.00

260

QC

Memo

0.00

Quality Control

 20150908

MC SEP 08 2015

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Page 1

Work Order ID: 135671

135671

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 8/14/2015

Required Date: 8/14/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verf: DD IPP Rev: L 12.11.22 now swage per ecn12-679 DD verf: JLM IPP Rev: M 14.04.25 ECN14-520 DD verf: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CCR264SS3-3	CCR264SS-3-03	Purchased	No				Each	0.0000		2	1286006	15-8-27	Dec
CCR264SS3-3									**				
Cherry Rivet													
CR3212-4-03		Purchased	No				Each	500.0000		2			
CR3212-4-03									**				
Cherry Rivet													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					CCR004	500							
					119017	500							
D2620		Manufactured	No				Each	5.0000		1			
D2620									**				
Skidtube, 206 Skidtube													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					LG002	5							
					126930	1							
					135311	4							
D2647		Manufactured	No				Each	0.0000		1			
D2647									**				
Cap													

① DGC 15-8-27

① DGC 15-8-19

BE15-08-20

8134879

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Work Order ID: 135671

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Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 8/14/2015

Required Date: 8/14/2015

Start Qty: 1.00

Required Qty: 1.00

D2654-5

Manufactured No

Each

5.0000

1

D2654-5

Web

Location

Loc Qty

Loc Code

LG002

5

132476

1

134835

4

135935 xl Dec
15-8-26

D2680-041

Manufactured No

Each

17.0000

1

D2680-041

Nut Plate

Location

Loc Qty

Loc Code

LG

17

129083

17

Each

6.0000

1

D4956-11

Manufactured No

D4956-11

Wearplate Fwd

Location

Loc Qty

Loc Code

FP002

6

127081

6

Each

11.0000

1

D4956-23

Manufactured No

D4956-23

Wearplate Center Fwd

Location

Loc Qty

Loc Code

FP002

11

133386

5

133904

6

xl

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D206-642-341

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 8/14/2015

Required Date: 8/14/2015

Start Qty: 1.00

Required Qty: 1.00

D4956-35 Manufactured No

Each 15.0000 1

D4956-35

Wearplate Aft

**

11 15/08/10 3

Location

Loc Qty

Loc Code

FP002

15

133525

2

134219

13

X1

MS27039-1-08

Purchased No

Each 753.0000

2

MS27039-1-08

Screw

**

11 15/08/10 3

Location

Loc Qty

Loc Code

CA

96

m128636

96

FP001

365

m128636

365

X2

GA

2

125654

2

ST285

290

m128636

290

MS27039C1-08

Purchased No

Each 627.0000

54

MS27039C1-08

SCREW

**

11 13/08/10 3

Location

Loc Qty

Loc Code

ST273A

606

m132256

106

m132317

500

M1133064

X5J

ST283

21

126284

21

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Start Date: 8/14/2015

Required Date: 8/14/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

Each

3,042.000

1

NAS1149D0463.J

WASHER

all 13/08/03

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

1000

M132677

1000

ST269

2001

M127904

20

M129682

86

M130799

371

M132035

1399

M132317

125

X

D4720-1

Manufactured

No

150

Each

150.0000

19

19

D4720-1

Spacer

Location

Loc Qty

Loc Code

LG001

150

129566

150

ALS4-1032-130

AELS4-1032-130

Purchased

No

220

Each

1,591.000

54

54

ALS4-1032-130

Rivnut

19 Doc 15-8-27

all 13/08/03

Location

Loc Qty

Loc Code

st549

1591

M132317

391

M132954

1200

X 54

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Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 8/14/2015

Required Date: 8/14/2015

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

220

Each

55.0000

1

1

D2646

Aft Cap

all 15/08/02

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

51

103306

1

114495

1

127924

4

128761

1

132325

16

132326

28

xl

BLUE

D2651-1

Manufactured No

220

Each

168.0000

14

14

D2651-1

Plug

all 15/08/02

Location

Loc Qty

Loc Code

FP001

168

131695

30

132398

18

134571

120

xl

BLUE

D2651-3

Manufactured No

220

Each

228.0000

14

14

D2651-3

O-Ring

all 15/08/02

Location

Loc Qty

Loc Code

FP001

228

113577

16

120110

212

xl

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D206-642-341

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 8/14/2015

Required Date: 8/14/2015

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

220

Each

72.0000

6

6

D3537-1

Wearpad

all 13/09/10 2

Location

Loc Qty

Loc Code

FG	18	
79833	8	
88562	10	
FP001	45	
128225	1	
133512	9	
<u>134225</u>	35	
ST611	9	
125911	9	

x6

D3537-3

Manufactured No

220

Each

16.0000

1

1

D3537-3

Wearpad

all 13/09/10 3

Location

Loc Qty

Loc Code

FG	8	
86237	8	
FP001	6	
<u>132702</u>	6	
ST611	2	
120646	2	

x1

MS27039-4-06

Purchased No

220

Each

101.0000

1

1

MS27039-4-06

Screw

all 13/09/10 3

Location

Loc Qty

Loc Code

FP001	96	
<u>m132317</u>	96	
ST283	5	
m126534	5	

x1

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Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 8/14/2015

Required Date: 8/14/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

220

Each

4,955.000

54

54

NAS1149C0332R

WASHER

ll 13/08/03

Location

Loc Qty

Loc Code

FP001

2140

m130325

2140

GA

221

m131618

221

ST260a

2000

m132930

2000

ST271

594

m129390

72

m132262

522

x54

NAS1149D0332J

Purchased

No

220

Each

2,210.000

2

2

NAS1149D0332J

Washer

ll 13/08/02

Location

Loc Qty

Loc Code

CA

14

m129682

14

GA

622

m132677

622

ST269

1574

m130325

900

m131624

46

m132677

628

12

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QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

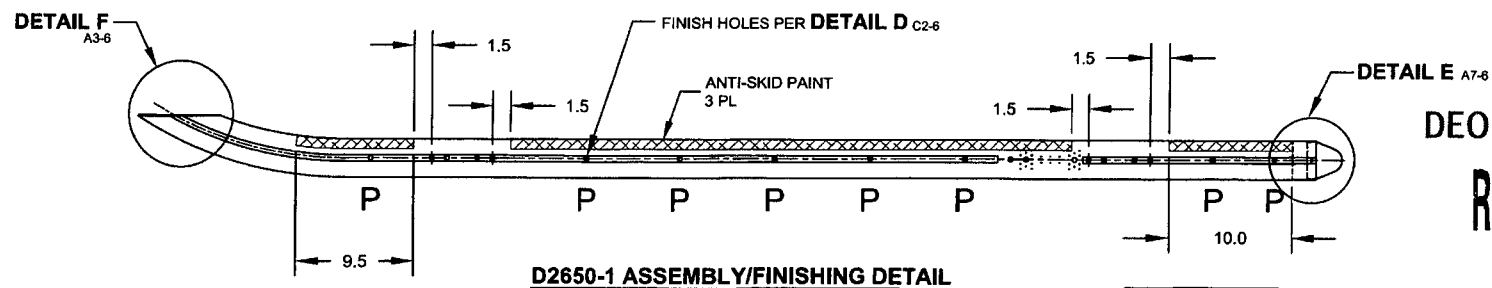
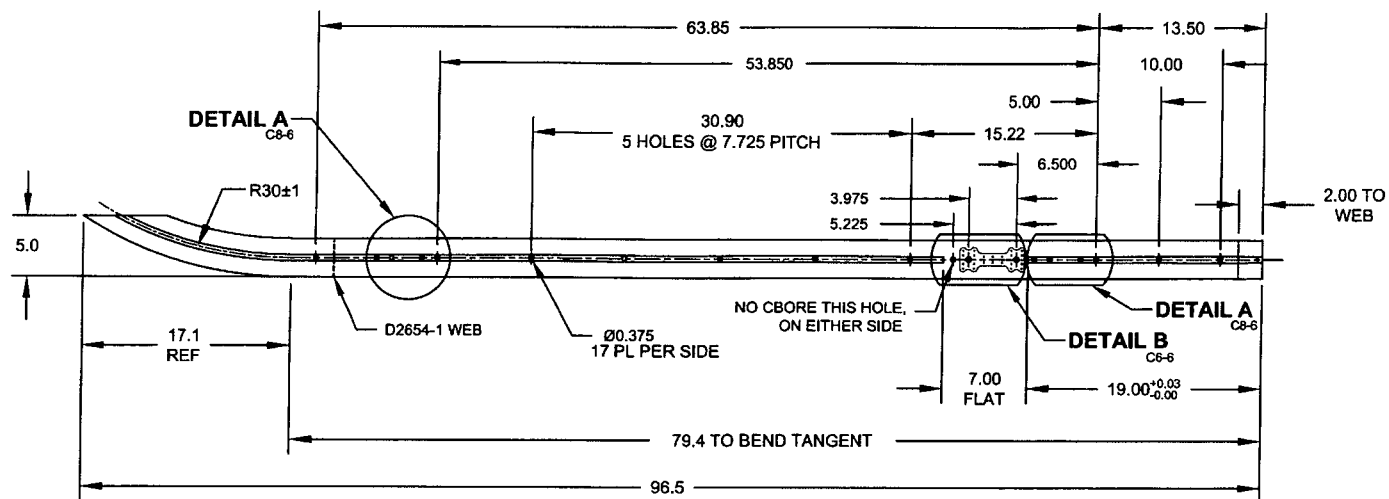
STOP COPY
RETURN TO
DART AEROSPACE
COPY
DELETED FROM NOTE 7 (SEE NCR 239)

135671 MLS
150817

DEO ATTACHED

RELEASED
08-07-23

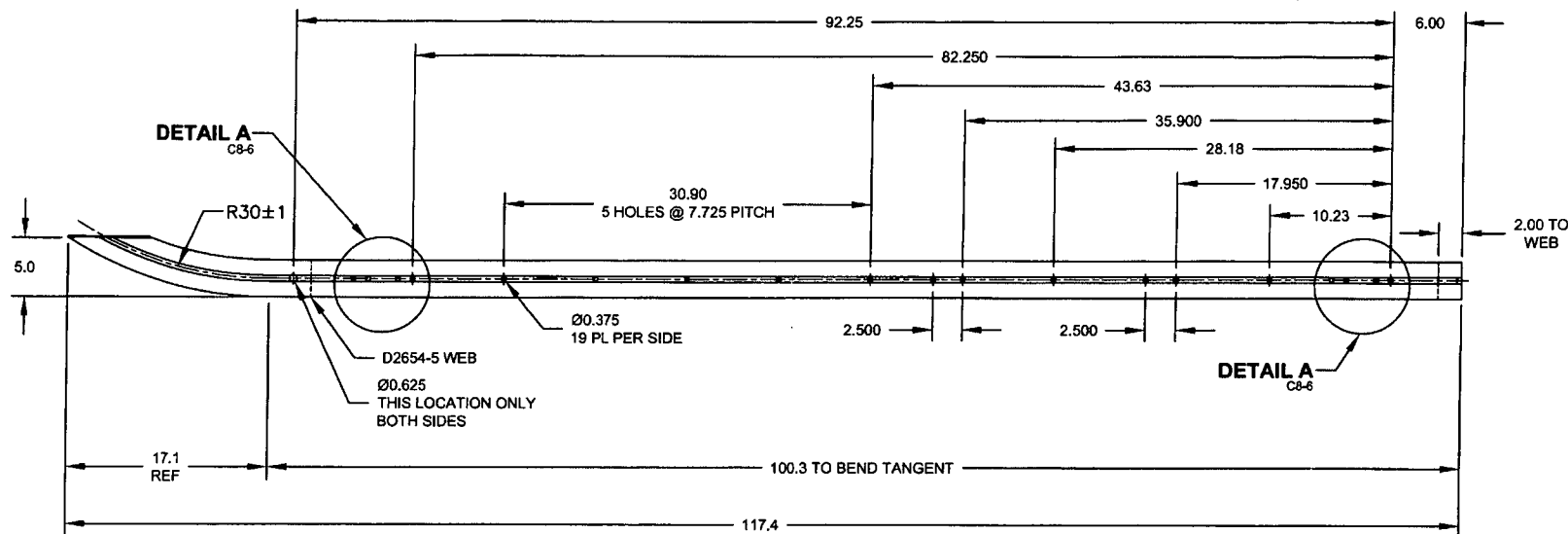
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239)	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR CONSEQUENCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



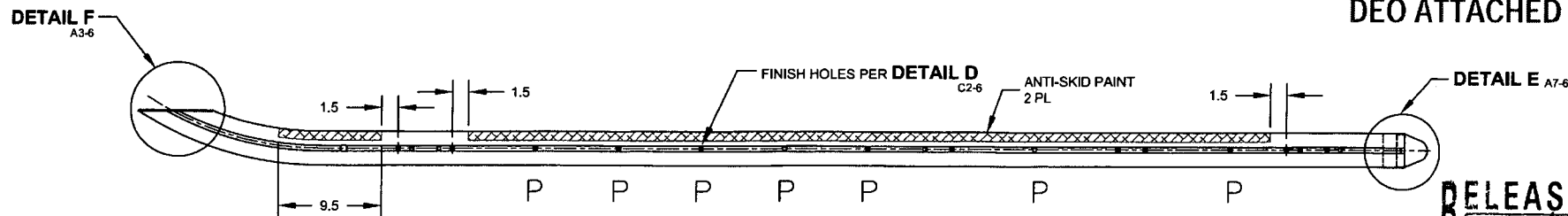
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DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
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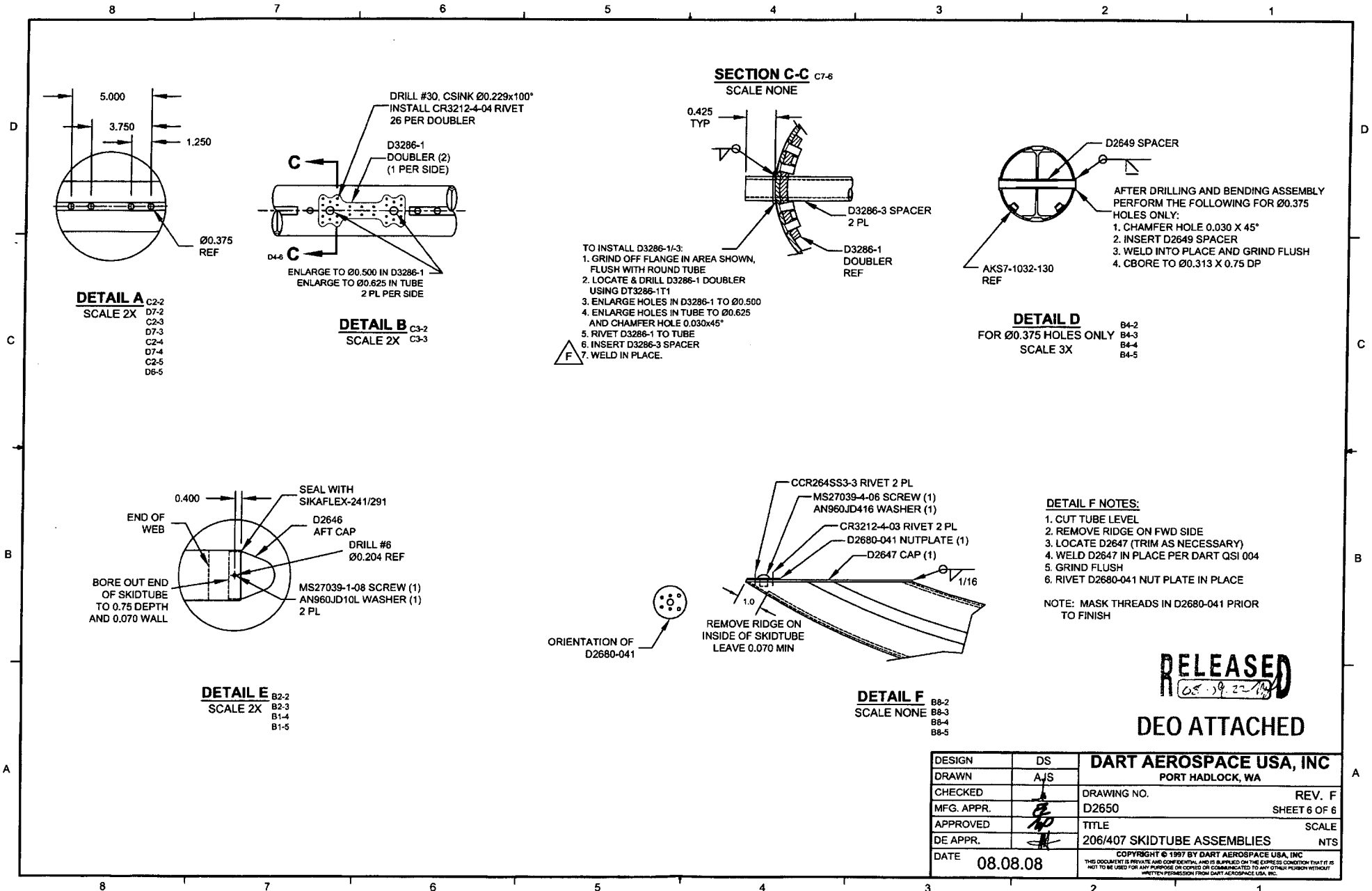
D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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8 7 6 5 4 3 2 1



DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>[Signature]</i>	CHECKED A.P.	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

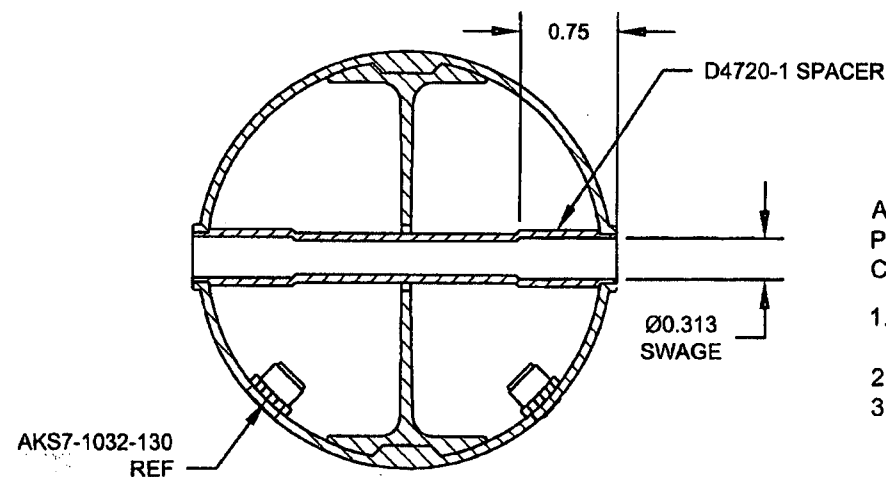
IS:

QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-1	-3	-5	-7		
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
----	----	----	----	-------	-------------------

ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.
C'BORED HOLES ARE **NOW SWAGED** PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).

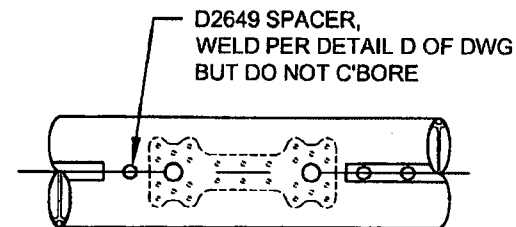


DETAIL G

FOR Ø0.375 HOLES ONLY

FOR HOLES THAT ARE CURRENTLY C'BORED ONLY

NOT TO SCALE



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16
[Signature]

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

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